

Work Order ID 133304

133304

Page 1

Monday, June 01, 2015 2:21:50 PM

Item ID: D350-689-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Dual High Back Seat Assembly

Start Date: 6/1/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ME Date: 15-6-01 Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN D350-689

C

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefiles and create labels as per PPP D350-689-041 CHG003

N/A MS JUN 10 2015

140

0.00

140

Small Fab

Large Fab

Memo

0.00

Small Fab

ASSEMBLE STUD, SPRING AND LOCK AS PER IIN SHEET 17

already done in D5162-041 #130269 ME 15-6-11

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

① 13.06.1 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 133304

133304

Page 2

Monday, June 01, 2015 2:21:51 PM

Item ID: D350-689-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Dual High Back Seat Assembly

Start Date: 6/1/2015 Start Qty: 1.00 *1*

Required Date: 6/5/2015 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-041								
	Location: _____								
	PPP Rev: <u>129839</u>								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

JUN 05 2015

1

DAS
6
9-88

ME
15-6-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
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Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

Monday, June 01, 2015 2:21:50 PM

133304

D350-689-041

Required Date: 6/5/2015

Required Qty: 1.00

Comments: IPP Rev:H Removed Sub-Parts 06-02-09 JLM
 IPP Rev:I As per NCR 070 06-09-06 JLM IPP Rev:J as
 per DSI 9498 DD 10.02.12 verified by:JLM IPP REV:K 15.02.12
 AS PER IIN REV.C DD VRF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3028-1 Stud		Manufactured	No				Each	20.0000		4			
D3028-1 used in assy 130269 MF 1-5-6-01													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST015		20							
				109929		10							
				130930		10							
D3029-1 Spring		Manufactured	No				Each	18.0000		2			
D3029-1 used in Rework #130269 MF 15-6-01													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		18							
				122745		18							
D3030-1 Lock		Manufactured	No				Each	10.0000		2			
D3030-1 used in Rework #130269 MF 15-6-01													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST015		10							
				111519		1							
				127859		9							
D5162-041 Seat Structure Assembly		Manufactured	No				Each	0.0000		1			
D5162-041 130269 MF													

15-06-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

December-17-14 1:29:07 PM

Page 2

Work Order ID: 127511

127511

Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 1/01/15

Required Date: 1/01/15

Start Qty: 1.00

Required Qty: 1.00

D3023-1

Manufactured No

100

Each

2.0000

1

1

D3023-1

Back Panel

EL 15-1-18

Location

Loc Qty

Loc Code

WA001

2

1270854

126276

1

126277

1

D3024-1

Manufactured No

140

Each

5.0000

3

3

D3024-1

Spacer

15/01/27

DAS
36
9-89

Location

Loc Qty

Loc Code

ST015

5

111838

5

D3028-1

Manufactured No

140

Each

30.0000

4

4

D3028-1

Stud

B127195 (3x)
15/01/27

Location

Loc Qty

Loc Code

ST015

30

109929

14

124022

16

D3029-1

Manufactured No

140

Each

28.0000

2

2

D3029-1

Spring

15/01/27

DAS
36
9-89

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

28

122745

28

December-17-14 1:29:08 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

December-17-14 1:29:08 PM

Page 3

Work Order ID: 127511

127511

Parent Item: D350-689-041

D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 1/01/15

Required Date: 1/01/15

Start Qty: 1.00

Required Qty: 1.00

D3030-1

Manufactured No

140

Each

8.0000

2

2

D3030-1

Lock

15/01/27 DAS 36 9-89

Location

Loc Qty

Loc Code

ST015

8

111519

5

116996

3

140

Each

21.0000

2

2

D3031-1

Manufactured No

D3031-1

Loop

3127859 15/01/27 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

21

124064

20

79747

1

Each

1,203.000

40

MS20600-AD4W2

Purchased

No

MS20600-AD4W2

Rivet

15/01/20 DAS 36 9-89

Location

Loc Qty

Loc Code

CCK004

889

m126475

889

GA

314

m125708

314

40

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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